Work Orde	r ID 92376			*923	376*						Page 1
Revision ID:	D350-578-031 Wearplate			Accept	*N900	040	100)* s	Setup Star	IV	S1* S2*
Start Date: 1 Required Date: 1 Reference:		rt Qty: 1.00 'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
	Process Plan:	MLJ	Date:\\2-\\0-3\\			ate:		F	Run Star Sto	" [/]	R1* R2*
Sequence ID/ Work Center ID		ration cription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision	Nbr									
DS19429 IIN D350-578	RevA RevA		16	, C	45					1	
100 *100* DC	DOC	UMENT CONTRO	l.	0.00 J	5 /				Ha	Of MC	T/2-11-1
Document Control		001	luefile and type labels per	PPP D350-578-031 and	DSI9429 CHG						
105	Pick 1	Kit		0.00							
105 Packaging Packaging		Memo	0	0.00							12(11/07/j

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE	•
QA Closed:	Date:
Work Order: DISPOSITION AGAINST DEPARTMENT/P	PROCESS Water Jet Engineering
Part No. Scrap Machining Small Fab Prod. Use-as-is Thermoforming Finishing Rec/Store,	Eng. Coor. Quality //Packaging Other
NCR No Work Order Update Large Fab Composite	Supplier
Root Description of work order update Initial Action Sign &	
Cause Date Step Qty or Non-conformance Chief Eng Description Date	Verification QC Inspector
Doc/Data	
Equip/Tooling	
Operator	
Material	
Setup Other	
Other	
Process Supplier 3 2	i i
Training	İ
Unapproved	
FAULT CATEGORY	
Landing Gear General Bending Bend Grain Ovalized	Pressure/Forced
Centre Not Concentric to O/S BOM/Route Hardware Over/Under to	
Cracks Broken/Damaged Inspection Incomplete Part Incorrect	
Crushed/Crimped. Burrs Instructions Incomplete Part Lost/Miss	⊢
Cuffs Contamination Maintenance Part Moved	Sing Wrong Stock Fulled
Heat Treat Countersink Mislabeled Positioned Wr	rong
Inspection Strip in Tube Cut Too Short Misread Power Loss/Su	
Ripples in Bend Drill Holes Offset	arge [Journey
Torque Waves in Extrusion Drawing Out of Calibration	
Turning Sequence Finish Out of Sequence	

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde				*923	376*							Page 2
Revision ID:	D350-578-0 Wearplate	031		Accept	*N900	040	100)*	Setup	Start Stop	171.	S1* S2*
Start Date: Required Date: Reference:	10/23/12 11/09/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:				,		
Approvals:	Process Pl	lan:	Date:	Tooling:	Da	te:	-		Run	Start	1/11	R1*
	QC:		Date:	SPC (Y/N):	Da	te:				Stop	*NI	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re		Reject Number	Insp. Stamp
*110 *110* QC		QC4- 100% Inspect kits Memo	for completeness	0.00	045 15]				
Quality Control		Memo		19	1108							
120		D. L. C		0.00			(, , ,	a 0
120 Packaging		Packaging Memo		0.00			((10)	-		12/11/	824
Packaging				PPP D350-578-031 and D	519429							1 20
130		QC21- Final Inspection	- Work Order Release	0.00						1	7/11	/8 D
QC Quality Control		Memo		0.00								,,, = 0
											MLJ.	12-11-0

NCR:	Yes	/ No				WORK ORDER NON-O	100	VFORM	MANCE / UP[DATE			•
											QA Closed:	Date	:
Work Orde	er:					DISPOSITION				AGAINST DI	EPARTMENT,	PROCESS	A ,
Part f	_					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root						ption of work order update		Initial	Act		Sign &	•	
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data	Ш						1						
Equip/Tooling													
Operator	Ш												1
Material	Щ					*							
Setup	Щ												
Other	Ш												
Process	Н												
Supplier	Н												
Training	Н												
Unapproved			l		1			TCATE	CORY		1	<u> </u>	
1 41	<u>/</u>				`	•	AUI	LT CATE	GURY		·		
Landi	一				`	General		Grain		<u> </u>	Ovalized	Г	Pressure/Forced
	-	Bending	-t C		o/c	Bend BOM/Route	-	Hardwa		-	Over/Under	taloranco	Temperature/Cure
	-	Centre No	ot Conce	ntric to	U/S -	•	-	4		<u> </u>	⊣		Weld
	-	Cracks	C=:=========		-	Broken/Damaged	\vdash	4 '	ion Incomplete	inclose	Part Incorre)	Wrong Stock Pulled
	-	Crushed/ Cuffs	Crimpea.		-	Burrs	-	Mainte	tions Incomplete/U	Inclear	Part Lost/M Part Moved	issuid [
	Н	Cums Heat Trea			-	Contamination Countersink	-	Mislabe		 	Part Woved Positioned	Mrong	
				Tubo	-	Cut Too Short	-	Misread		 -	Positioned (Other
	-	Inspectio Ripples in	•	rube	-	Drill Holes	-	Offset	,	<u></u>	Trower ross	Juige [Torrier
	-	Rippies in Torque W		Extrusio	n —	Drawing		-1	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

Picklist Print

October-30-12 9:21:44 AM

Work Order ID:

92376

Parent Item:

D350-578-031

IPP Rev:A 09-02-03 new issue DD verified by:JLM

Parent Item Name:

Wearplate

Start Date: 10/23/12

123021

Required Date: 11/09/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments: Component Item ID/ Last Unit of Qty on Qty per Kit Total Qty Replacement Date Statz Mfg/ Bin **Primary** Route Item Name Item ID Location Measure Hand Issued Issued Purch Item Location Seq ID Qty 105 539.0000 No Each 12 AN4H7A Purchased Location Loc Code Loc Qty ST357 500 122416 500 122416 ST358 34 0 116704 121541 34 ST359 5 0 112314 121068 5 D38592041 105 Each 5.0000 No Manufactured Location Loc Qty Loc Code ST500 5 84015 4 1188685 88685 MS21042124 No 105 Each 6,281.0000 12 ~ Purchased Loc Code Location Loc Qty 314 754 122452 754

27

20 7

5500

3000

900

1600

ST300

ST314

119017

121444

123021

123248

123355

										DQA:	Date:	
NCR: Y	es / I	lo			WORK ORDER NON-O	100	VFORN	ANCE / UPI	DATE			•
	•									QA Closed:	Date:	
Work Orde	~ · ·				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	*
WOIK OIGE	=1.				Rework	7		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	No			*	Scrap		ľ	Machining	Small Fab	4	d. Eng. Coor.	Quality
NCR N	No				Use-as-is Work Order Update	}		oforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root	•			Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause	Da	te Ste	o Qty		or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material						1						
Setup												
Other												
Process												
Supplier												
Training												
Unapproved												
					F	AUI	LT CATE	GORY				
Landi	ng Gear				General		=			-		_
,	Bend	ing			Bend		Grain			Ovalized		Pressure/Forced
	Cent	e Not Con	centric to	O/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crac	s			Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crusi	ed/Crimpe	ed.		Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat	Treat			Countersink		Mislabe	led		Positioned \	Wrong	_
	Inspe	ction Strip	in Tube		Cut Too Short		Misreac	I		Power Loss,	/Surge	Other
	Ripp	es in Bend			Drill Holes		Offset				\ <u>-</u>	

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-30-12 9:21:44 AM

Work Order ID:

92376

Parent Item:

D350-578-031

Parent Item Name:

Wearplate

Start Date: 10/23/12

Required Date: 11/09/12

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J Washer

Purchased

No

105

Each

6,096.0000

12

Location	Loc Oty	Loc Code	
298	156		
122441	156		
ST294	4480		
123248	82		123355
123355	4398		<u> </u>
ST298	1422		
104746	1		
116805	0		
119073	20		
122452	1401		
ST299	38		
121912	38		

										DQA:	Date:	
NCR: Y	es / N	0			WORK ORDER NON-C	100	NFORM	ANCE / UPI	DATE			•
										QA Closed:	Date:	
Work Orde	ar:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	**
WOIK OIGE					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				-	Use-as-is		Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	10				Work Order Update			Large Fab	Composite		Supplier	
Root				Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause	Dat	e Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling											1	
Operator						1						
Material		1	*									
Setup			1									
Other												
Process												
Supplier												
Training												
Unapproved				:								
					F.	AUI	LT CATE	GORY				
Landi	ng Gear				General		_			_		_
	Bendi	ng			Bend		Grain			Ovalized		Pressure/Forced
	Centr	e Not Conce	entric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crack	5			Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crush	ed/Crimped	d.		Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat	reat			Countersink		Mislabe	eled		Positioned '	Wrong	_
	Inspe	ction Strip i	n Tube		Cut Too Short		Misread	i		Power Loss,	/Surge	Other
	Ripple	s in Bend			Drill Holes		Offset		-	_		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-578 REV. F OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-578 REV. 1 OR EARLIER
REF. TCCA STC: SH93-4
REF. FAA STC: SR00028NY
REF. FAA STC: SR00029NY
REF. EASA STC: EASA.IM.R.S.01389
REF. ARGENTINA STC: CTS-0508.13(A)

The D350-578-031 Wearplate kit can be installed on D350-578-011/-021 Bearpaw installations. The D3859-041 Wearplates should be installed on the D2432F or D2672F Bearpaws as shown in Figure 1 on Sheet 2 of this Service Instruction. The Bearpaws should otherwise be installed on the skidtube per installation instructions D350-578 Rev F or earlier.

Customers with old style bearpaws will need to rework the counterbore on the bottom of the bearpaws per Figure 1 on Sheet 2 of this service instruction.

WEIGHT AND BALANCE

Installation	Weight	La	teral	Longitudinal		
mstanation	Weight	Arm	Moment	Arm	Moment	
D350-578-031 Wearplate Kit	3.00 lb 1.36 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	157.0 in 3.99 m	471.0 in-lb 5.43 m-kg	

PARTS LIST

QTY. -031	PART NUMBER	DESCRIPTION
Х	D350-578-031	Wearplate Kit
2	D3859-041	Wearplate
12	AN4-17A	Bolt
12	NAS1149D0463J	Washer
12	MS21042L4	Nut or (MS21042-4)

UNCONTROLLETE SUBJECT TO ACCURA WITHOUT SECTOR ENGINEER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

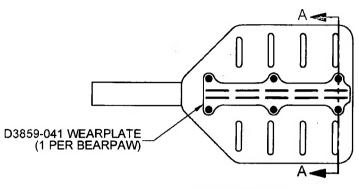
APRROVED

CERT. NO.: ISSUE NO ::

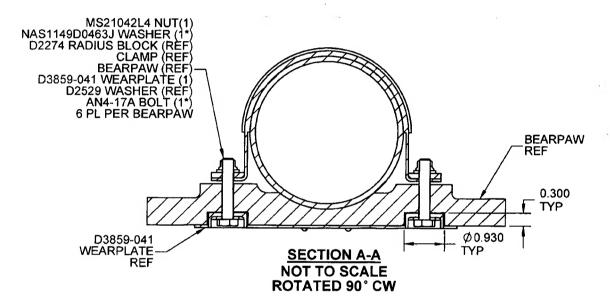
09.01.15 SH93-4

Α	NEW IS	SUE		35	09.01.15
REV.			DESCRIPTION	BY	DATE
DESIG	4	35	DART AEROSP	ACE L	TD
DRAW	1	35	HAWKESBURY, ONTA		-
CHECK	ED	B	DRAWING NO.		REV. A
MFG. A	PPR.	N/A	DSI 9429		SHEET 1 OF 2
APPRO	VED	149	TITLE		SCALE
DE APF	PR.	-#-	WEARPLATE KIT		NTS
DATE	09.0	1.15	COPYRIGHT © 2009 BY DAR! THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPINOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMU	LIED ON THE EXPRES	S CONDITION THAT IT IS





BOTTOM VIEW



* ADDITIONAL NAS1149D0463J WASHERS MAY BE INSTALLED UNDER NUTS TO ENSURE 1.5 - 4 THREADS IN SAFETY ON BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4-17A BOLTS WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

FIGURE 1: D350-578-031 WEARPLATE KIT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

APPROVED

D. SHEPHERD (DE # 02)

DATE: 09.01.15
CERT. NO.: SH93-4
ISSUE NO.: 7

DESIGN	95	DART AEROSPA	CE LTD
DRAWN	35	HAWKESBURY, ONTARIO,	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9429	SHEET 2 OF 2
APPROVED	142.	TITLE	SCALE
DE APPR.	#	WEARPLATE KIT	NTS
DATE 09.0	1.15	COPYRIGHT © 2009 BY DART AER THIS DOCUMENT IS PRIVATE AND CONTIDENTIAL AND IS SUPPLIED ON NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED WRITTEN PERMISSION FROM DART AEROST	THE EXPRESS CONDITION THAT IT IS TO ANY OTHER PERSON WITHOUT

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-578 REV. F OR EARLIER AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-578 REV. 1 OR EARLIER REF. TCCA STC: SH93-4

REF. FAA STC: SR00028NY REF. FAA STC: SR00029NY REF. EASA STC: EASA.IM.R.S.01389 REF. ARGENTINA STC: CTS-0508.13(A)

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PARTS LIST

QIY. (031)	PART NUMBER	DESCRIPTION Wearplate Kit	
X	D350-578-031		
-2-	D3859-041	Wearplate	
12	AN4-17A	Bolt	
412	NAS1149D0463J	Washer	
120	MS21042L4	Nut or (MS21042-4)	

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

BY: D SHEPHERD (DE # 02)

DATE: 09.01.15
CERT. NO.: SH93-4
ISSUE NO.: 7

Α	NEW ISSUE			1	09.01.15	
REV.		DESCRIPTION			DATE	
DESIG DRAW		DANI AEROSI AGE 212				
CHEC	KED	13	DRAWING NO.		REV. A	
MFG. APPR.		N/A	DSI 9429		SHEET 1 OF 2	
APPRO	OVED	149	TITLE		SCALE	
DE API	PR.	-11	WEARPLATE KIT		NTS	
DATE 09.01.15			COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CORPIDENTIAN UND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY DIRPOSE OR COPED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT MET TO BE USED FOR ANY DIRPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT MET TO BE USED FOR ANY DIRPOSE OR TO MET A REPORT ANY TO ANY OTHER PERSON WITHOUT MET TO BE USED FOR ANY DIRPOSE OR TO MET ANY DIRPOSE OF THE ORDER OF			